

Work Order ID 125912

Friday, October 24, 2014 11:14:11 AM

125912

Page 1

Item ID: D3631-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 11/03/14 Start Qty: 400.00

400

Cust Item ID:

Required Date: 11/14/14 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals:

Process Plan: *(Signature)*

Date: 14-10-24

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3631	Rev A

100

100

PURCHASING

Purchasing

Memo

0.00

CD 14/10/27 400

Purchasing

Issue P/O: *26267* Purchase Part Number: 95606A170 Supplier: Mc
Master Carr Certificate of conformity is required

110

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

100 X SP 14-10-30

120

120

QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

DAS

9-89 38

9-89

OCT 30 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other				

Work Order ID 125912

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125912

Page 2

Item ID: D3631-1

Accept

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Setup Start

NS1

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Item Name: Washer

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NS2

Start Date: 11/03/14 Start Qty: 400.00

400

Cust Item ID:

Required Date: 11/14/14 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP601

0.00

DAS

46

130

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

400X

9-89

OCT 30 2014

140

QC

Quality Control

Memo

0.00

14/11/30

Aru-10.31

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Friday, October 24, 2014 11:14:15 AM

Page 1

Work Order ID: 125912

125912

Parent Item: D3631-1

D3631-1

Parent Item Name: Washer

Start Date: 11/03/14

Required Date: 11/14/14

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP Rev:A New Issue 07-07-28 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
95606A170		Purchased	No			110	Each	0.0000	1	400	**	400X	SP/14-10-30

95606A170

Washer

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
NCR No. _____									

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

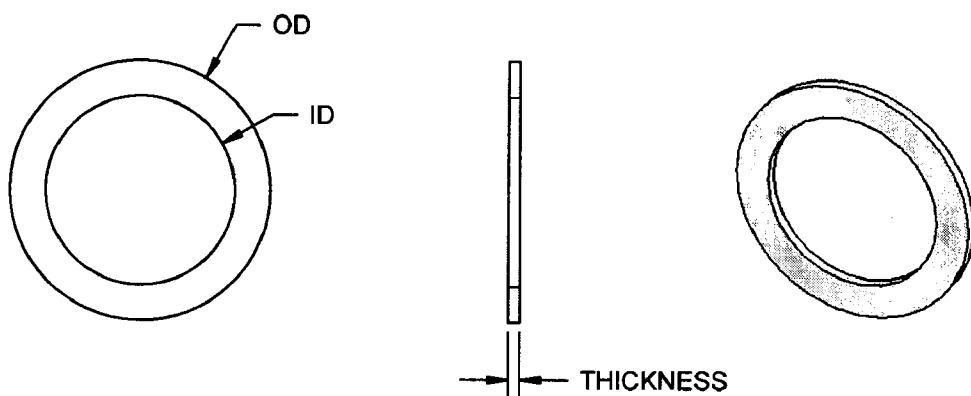
FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3631	REV. A	SHEET 1 OF 1
DATE 07.05.16		TITLE WASHER	SCALE	
REV A	DATE 07.05.16	DESCRIPTION NEW ISSUE		NTS

SPECIFICATION CONTROL DRAWING



D3631-X WASHER

RELEASED
07.08.02 *#*

PART NUMBER	OD	ID	THICKNESS	MATERIAL	SUPPLIER
D3631-1	0.688	0.500	0.031	NYLON	McMASTER-CARR P/N: 95606A170

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

*2014-10-24
12912*

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26267

Purchase Order Date 10/27/2014

PO Print Date 10/27/2014

Page Number 1 of 6

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Customer POID	
	Customer Tax #	10127-2607
Ship To Contact	Terms	Net 10
Ship To Phone	Currency	USD
Ship Via:	FOB	FCA - (Free Carrier)
Ship Acct:		

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extende Price
				Promise Date			
1	59915K274	Rod End Bearing	10/29/2014 Yes 10/29/2014		12.00 Each	\$17.14	\$205.68
	AS PER DWG D4777 REV. A B125796					Line Total:	\$205.68
	95606A170	Washer	10/29/2014 Yes 10/29/2014		400.00 Each	\$0.10	\$40.00
	AS PER DWG D3631 REV. A B125912					Line Total:	\$40.00
	DAS 38						
	71400-30	9066T11 CABINET	10/29/2014 Yes 10/29/2014		1.00 Each	\$368.28	\$368.28
						8/14/1030	

Note:

200 Aurora Industrial Pkwy
 Aurora OH 44202-8087
 330-995-5500
 cle.sales@mcmaster.com

Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Purchase Order
PO26267
 Order Placed By
 Chantal Lavoie
 McMaster-Carr Number
2889466-02

Page 1 of 2
 10/27/2014

Line	Product	Ordered	Shipped
1	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	12 Each	✓
2	95606A170 Plastic Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	4 Packs	✓
3	9066T11 Standard Pedestal Workbench Base, 3 Drawer with Base, 15-3/4" W X 20" D X 32" H, Dark Gray Your Part Number: 71400-30	1 Each	✓
	Each includes:		
	9066T57 Base Unit, 15-3/4" W X 19" D X 5" H for, Standard Pedestal Workbench Base	1 Each	
	9066T58 Standard Pedestal Workbench Base, Three Drawer Pedestal, 15-3/4" W X 20" D X 27" H	1 Each	
4	9066T13 Standard Pedestal Workbench Base, Cabinet with Base, 15-3/4" W X 20" D X 32" H, Dark Gray Your Part Number: 71400-30	1 Each	✓
	Each includes:		
	9066T55 Standard Pedestal Workbench Base, One Door Cabinet Pedestal, 15-3/4" W X 20" D X 27" H	1 Each	
	9066T57 Base Unit, 15-3/4" W X 19" D X 5" H for, Standard Pedestal Workbench Base	1 Each	
5	4882T14 Maple Workbench Top, 60" Width X 24" Depth X 1-3/4" Thick, Radius Edge Your Part Number: 71400-30	1 Each	✓
7	5099A33 Hole-Grip Clamp, Fits 3/16" Diameter Your Part Number: 71500-20	15 Each	✓
8	9381T24 Zinc-Plated Steel Open End S-Hook, 1/8" Diameter, 28# Work Load Limit, Packs of 25 Your Part Number: 71500-40	75 Packs	✓
9	5274A12 Easy-Read Adjustable Click-Style Torque Wrench, 3/8" Square Dr, 5-80 ft-lbs/5-110 NM Torque Range Your Part Number: 71500-30	1 Each	✓
10	90666A136 Type 316 Stainless Steel Low Profile Socket Head Cap Screw, M8 Size, 12 mm Long, 1.25 mm Pitch, Packs of 10 Your Part Number: 71500-30	1 Pack	✓
12	8860K64 Bend-and-Stay 302/304 Stainless Steel Wire, 0.041" Diameter, 1 lb Can, 220' Long Your Part Number: 71400-40	3 Each	✓